

DT 8728



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2933-1

Job Sheet 203783



Part No: D2933-1

Job Qty: 6 pcs

Part Name: Saddle LH In, 206



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/27/19

Job Tracking No:

Due Date: 1/13/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev (mpp 2069) EC IPP Rev:C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs	1/13/20	0.40	8.88		HAAS - 1		SJP 20/02/14
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	6 pcs	1/13/20	0.00	0.37		Conventional Mill - 1 - B4B		SBL 20/02/15
							Conventional Mill - 2 - B4B		
120	QC 2	6 pcs	1/13/20	0.00	0.00		QC 2 - 1		SBL 20/02/15
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		



Container No: S256028



Part: D2933-1

Job No: 203783

Serial No/Batch: S256028

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/14/20

Plex 11/27/19 12:13 PM Dart.Renwick.Jennife

				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	6 pcs	1/13/20	0.00 0.00	QC 8 - 12	20/02/16
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	1/13/20	0.00 0.29	Handfinish - 1 - 1 - B4B	FEB 17 2020
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	

Plex 11/27/19 12:13 PM Dart.Renwick.Jennife

Plex 11/27/19 12:13 PM Dart.Renwick.Jennife

				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	6 pcs	1/13/20	0.00 0.00	QC 21 - SA - 21	FEB 26 2020
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (HAAS CNC Vertical Machine) Program part number and batch number. 2-Machine Step No 1 of Folio and visually Descriptions: inspect as per dwg D2933 & attached Dimension Sheet 110 - (Manufacture as per dwg) Machine Keyway and inspect per attached dimension sheet 120 - QC2- Inspect parts off machine FAI/FAIB 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6101-001	Saddle Billet	6 pcs (1 ea)	100-HAAS 4 Axis	S235965	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	D6101-001	6	18	0	
Part Specifications					
Specifications could not be found.					

Plex 11/27/19 12:13 PM Dart.Renwick.Jennifer

DART AEROSPACE LTD				Work Order: 203783	
Description: 206 Saddle, Inboard, Left side				Part Number: D2933-1	
Inspection Dwg: D2933 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.125	0.126	0.126	0.126	
B	0.100	0.140		0.124	0.124	0.123	0.123	
C	0.100	0.140		0.118	0.117	0.117	0.117	
D	0.210	0.230		0.227	0.226	0.226	0.226	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		0.511	0.511	0.511	0.511	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		0.258	0.258	0.258	0.258	
L	0.312	0.317		0.313	0.313	0.313	0.313	
M	0.235	0.240		0.238	0.238	0.238	0.238	
N	0.100	0.140		0.120	0.119	0.118	0.119	
O	0.540	0.560		0.547	0.548	0.548	0.548	
P	0.490	0.510		0.497	0.497	0.499	0.498	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.470	2.510		2.500	2.494	2.494	2.494	
S	0.240	0.270		0.254	0.257	0.256	0.257	
T	0.100	0.180		0.130	0.133	0.132	0.133	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		0.316	0.316	0.316	0.316	
X	1.125	1.145		1.135	1.135	1.135	1.135	
Y	1.565	1.585		1.575	1.575	1.575	1.575	
Z	0.178	0.198		0.188	0.188	0.188	0.188	
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: DTP/5B2	Date: 20-02-14 / 20/02/15
Audited by: MK	Date: 20/02/16
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

DART AEROSPACE LTD		Work Order:	203783
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				5	6	7	8	9
A	0.100	0.140		.126	.127			
B	0.100	0.140		.123	.123			
C	0.100	0.140		.117	.117			
D	0.210	0.230		.226	.225			
E	1.245	1.255		1.125	1.125			
F	1.245	1.255		1.125	1.125			
G	2.495	2.505		2.500	2.500			
H	0.510	0.515		.511	.511			
I	1.572	1.582		1.577	1.577			
J	2.495	2.505		2.500	2.500			
K	0.257	0.262		.258	.258			
L	0.312	0.317		.313	.313			
M	0.235	0.240		.238	.238			
N	0.100	0.140		.119	.118			
O	0.540	0.560		.548	.548			
P	0.490	0.510		.499	.499			
Q	3.715	3.725		3.720	3.720			
R	2.470	2.510		2.494	2.494			
S	0.240	0.270		.257	.257			
T	0.100	0.180		.133	.133			
U	1.625	1.635		1.630	1.630			
V	1.362	1.372		1.367	1.367			
W	0.316	0.321		.316	.316			
X	1.125	1.145		1.133	1.135			
Y	1.565	1.585		1.575	1.575			
Z	0.178	0.198		.188	.188			
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: SBZ	Date: 20/02/15
Audited by: [Signature]	Date: 20/02/16
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	[Signature]